

# Work Order ID 73450

Thursday, September 01, 2011 7:31:16 AM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/09/01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536  
2-Deburr

11/09/14 (6)

110



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Subwork

11/09/22

120



Weld per dwg A/R S.S. rod Batch: 1114649

0.00

Small Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

Large Fab

11/09/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73450**

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.09.23 @

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/09/23



150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00

320°F

10:30

6x0 m-11/09/23

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 73450**

Thursday, September 01, 2011 7:31:16 AM



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Item ID: D2530

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Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

C S Helord

170

Identify as per dwg &amp; Stock Location: 506

0.00



Packaging

Memo

0.00

Packaging

11/9/23 D S

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/23 MF 11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 7:31:13 AM

Page 1

Work Order ID: 73450

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F  
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

281.8496

2.9145

18.40737



304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

281.84963

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

3.09263

117797

0.75

117983

143.091

118390

100

D2534

Manufactured

No

120

Each

2.0000

2

12



Lock Plate

Location

Loc Qty

Loc Code

WA

73812

2

70996

2

10

2

18.40737

PMB 11/09/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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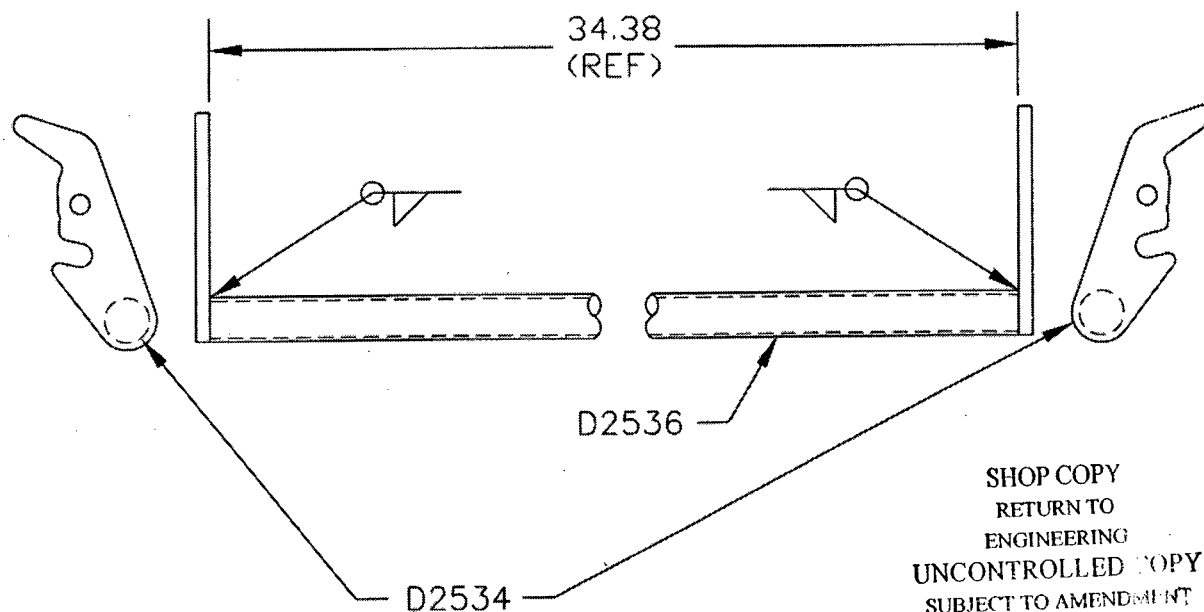
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>PH</i>	APPROVED <i>PH</i>	D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *PH*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73450

*CL11109101*D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED